

Date: Wednesday, 3/14/2007 12:25:42 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 31196		
Estimate Number	: 12462		
P.O. Number	: N/A	Part Number	: D35083
This Issue	: 3/14/2007 S.O. No. : N/A	Drawing Number	: D3508 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28968	Material	: N/A
Written By	:	Due Date	: 3/30/2007 Qty: 8 Um: Each
Checked & Approved By	:		
Comment	: Est Rew A New Issue 06-06-20 JLM Est Rev:B Now SS as per Rev B 06-12-15 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.7707 sf(s)/Unit Total : 6.1656 sf(s)  
 304 SS .038" THK (20GA)  
 (M304S20GA)  
 Batch: ~~H101373~~ m103713

⑧

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3508  
 Dwg Rev: B  
 Prog Rev: B

SAD 07/03/17 ⑧

2-Deburr if necessary

07/03/27 dm ⑧

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/17 ⑧

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/03/19 ⑧

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE  
 1-Form on brake using DT8326 and DT8261 as per Dwg D3508  
 2-Form joggle as per Dwg D3508 Using DT8158

MF 07-03-27 ⑧  
SB 07/03/28 ⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PL Date: 07/03/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31196

Part Number: D35083

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*0703-28 (8)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



*M 10/601*



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*Feb 07/03/28 (8)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*m-h*



*(8x) 07/03/28*

Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



*(8x)*

Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *FP*

*m-h 07/03/28*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



*(8)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/03/29*

Job Completion



*U 07-03-29*

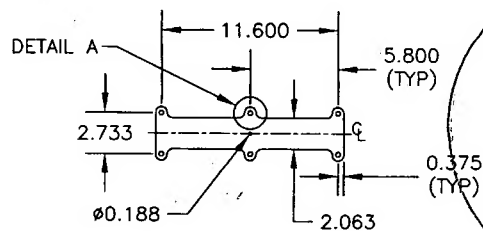
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

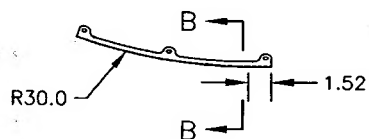
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

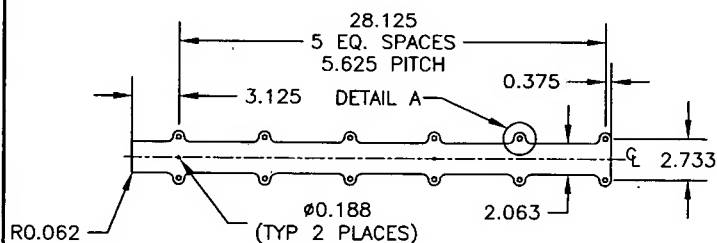
NOTE: Date & initial all entries



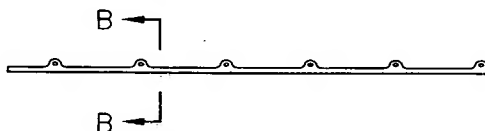
**D3508-1 FLAT PATTERN**



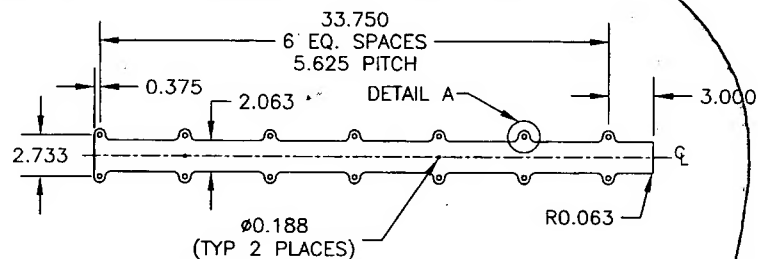
**D3508-1 BENDING DETAIL**



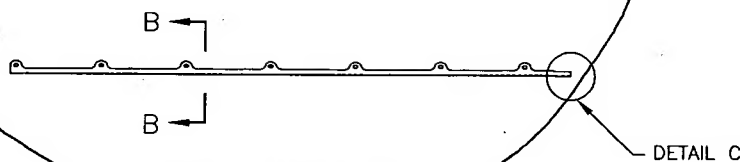
**D3508-5 FLAT PATTERN**



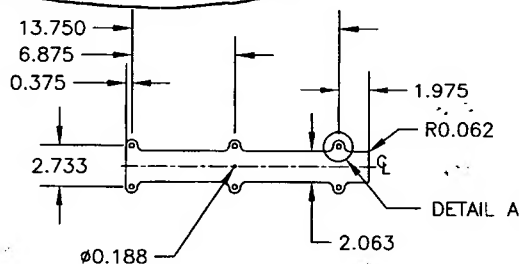
**D3508-5 BENDING DETAIL**



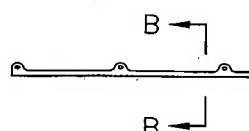
**D3508-3 FLAT PATTERN**



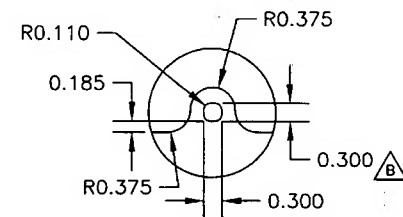
**D3508-3 BENDING DETAIL**



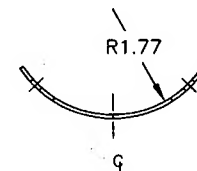
**D3508-7 FLAT PATTERN**



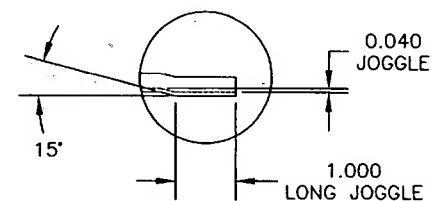
**D3508-7 BENDING DETAIL**



**DETAIL A  
SCALE 1:2**



**SECTION B-B  
SCALE 1:2**



**DETAIL C  
SCALE 1:2**

**D3508-1/-3/-5/-7 WEARPLATE NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK) (REF DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

B	06.10.27	CHANGE STAINLESS STEEL, WIDEN TAB
A	06.04.21	NEW ISSUE
DESIGN	DH	DRAWN BY
CHECKED	TH	APPROVED
DATE	06.10.27	TITLE
		WEARPLATE

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, WA  
DRAWING NO. D3508  
REV. B  
SHEET 1 OF 1  
SCALE 1:8

RELEASED

06.12.12

NO. 31196  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31196
<b>Description:</b> Wear Plate		<b>Part Number:</b> D35083
<b>Inspection Dwg:</b> D3508	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	2.733	+/- 0.010	2.731	✓		Vern	
B	0.375	+/- 0.010	0.380	✓		Vern	
C	2.063	+/- 0.010	2.070	✓		Vern	
D	5.625 (Pitch)	+/- 0.010	5.620	✓		Vern	
E	33.750	+/- 0.010	33.750	✓		Vern	
F	Ø 0.188	+0.005 -0.001	Ø 0.190	✓		Vern	
G	0.300	+/- 0.010	0.300	✓		Vern	
H	0.300	+/- 0.010	0.301	✓		Vern	
I	0.038	+/- 0.010	0.032	✓		Vern	
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

<b>Measured by:</b> SJD	<b>Audited by:</b> JL	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/03/17	<b>Date:</b> 07/03/17	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
		New Issue	KJ/RF	